

Work Order ID 54584

December 14, 2009 1:10:30 PM

Page 1

Item ID: D205-634-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 14/12/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

8106115

110

0.00



CNC Bend I

BENDING MACHINE - SKIDTUBES

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio FT009

2-Cut tubes as per Dwg. D2580

09-12-14

11/12/17

54584

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

1 - - AWM 9-12-30

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

D - BR 10/01/04

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Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Weld step D2576 as per Dwg. D2580 and QSI 004
A/R 001 Aluminum Rod *m112860*

BE 10/01/04

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill
A/R 001 Aluminum Rod *m112860*

BE 10/01/04

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64",
adjust stopper not to hit web. Debur

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580.
Debur holes

Q.m 10-01-08

6-Drill pilot holes for aff cap using DT 8215 Open holes to 0.208". Debur

7-Drill pilot holes for Towing using DT8091, open to .640" and Debur

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Reference:

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

=> S 10/01/11



Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

=> S 10/01/11



Quality Control

170

Pressure Wash per QSI005 4.3

0.00

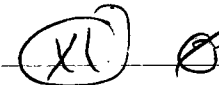


HandFinish

Memo

0.00

=> S 10/01/11



Hand Finishing

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

M113170

8:15AM

320°F

8:45AM

0.00

10/01/12

40

0

190

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

BR 10-01-13

1

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

0.00



HandFinish

Memo

0.00

Hand Finishing

1-Install inserts & wearplates & Gaskets as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates
A/R ☐ ☐ ☐ Sikaflex-291 11/12/05
Sikaflex expire date: 12/08

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive
A/R ☐ ☐ ☐ Sikaflex-291 11/12/05
Sikaflex expire date: 12/08

5-Wing Walk as per Dwg D2580 and QSI 005 4.4
Batch: 112900

Handwritten signature and date: 12-01-14.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 21/12/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date:

Tooling:

Date:

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 04

220

Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location:

PPP Rev: F

230

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/01/18
MF 10-1-15

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 54584

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 14/12/2009

Required Date: 21/12/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Ro Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2580-1		Manufactured	No			110	Each	7.0000	1.0000			

205 Skidtube bent detail

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

4

54120

2

54279

2

Main Warehouse

ST

3

53540

1

54121

2

D2576-3

Manufactured No

140

Each

156.0000

1.0000



Step (maching detail)

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

ST

156

43504

8

46661

101

52215

47

B54647

DP 9-12-17

★

1

BE 10/01/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Parent Item Name: Replacement Skidtube


Start Date: 14/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2579  Crossbolt Spacer		Manufactured	No			140	Each	363.0000	20.0000			



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

241

51525

4

53780

130

54543

107

Main Warehouse

ST

122

43988

4

46434

4

46956

2

47797

9

48272

2

51314

71

51315

30

D2855

Manufactured

No

200

Each

55.0000

1.0000

Cap



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP6

53791

55

50513

1

50770

3

51539

51

1 BR 10-01-14.

W/O:		WORK ORDER CHANGES					
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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg. Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	#Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-5A		Purchased	No			200	Each	2,027.000	2.0000			
Bolt												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2027	
100188	188	
105057 ✓	1835	
15205	4	

2 10-01-14.

AN960JD10L

Purchased

No

200

Each

5,427.000 2.0000



Washer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5427	
101291	16	
104885	153	
105793	236	
109632 ✓	268	
110985	4754	

2 10-01-14.

W/O:		WORK ORDER CHANGES					
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Comments:

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ALS7-1032-130		Purchased	No			200	Each	2,080.000	50.0000			

Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2080	
105855	16	
108606	52	
111529	688	
111779 ✓	313	
112772	11	
113238	1000	

50 BR 10-01-14.

AN3C4A

Purchased

No

200

Each

1,661.000 50.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1661	
112314	13	
112720	12	
112724	3	
112829	1	
112991	2	
113121	74	
113226	990	
113359 ✓	66	
113422 ✓	500	

50 BR 10-01-14.

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin * Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L washer		Purchased	No			200	Each	500.0000	50.0000			

NAS 1149C0332R

Warehouse	Loc Qty	Loc Code
Location		
OFFSHORE		
FG	113288	
103585	100	
Main Warehouse		
ST	400	
112116	228	
112612	160	
112933	12	

50 12/10-01-14

D3566-13

Manufactured No

200 Each 100.0000 1.0000

Gasket

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	98	
51606	15	
53461	83	
Main Warehouse		
ST	2	
45717	1	
50265	1	

1 12/10-01-14

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D3566-5 		Manufactured	No			200	Each	26.0000	1.0000			
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP	22	
53804 ✓	22	
Main Warehouse		
ST	4	
36113	1	
46186	1	
47318	1	
51260	1	

1 BR 10-01-14.

D3566-1 		Manufactured	No			200	Each	22.0000	2.0000			
Gasket												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FP 54480	17	
52512	3	
53790	14	
Main Warehouse		
ST	5	
46349	1	
51218	1	
51259	3	

2 BR 10-01-14.

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D3564-11		Manufactured	No			200	Each	25.0000	1.0000			

Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP19 23

52125 ✓ 14

53808 9

Main Warehouse

ST 2

45823 1

50112 1

1 BK 10-01-14.

D3564-13

Manufactured No

200

Each

40.0000

1.0000



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP17 28

51611 ✓ 28

Main Warehouse

ST 12

45409 2

46495 10

1 BK 10-01-14.

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 14, 2009 1:10:35 PM

Work Order ID: 54584



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 14/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Da * Issued	Status
D3564-9		Manufactured	No			200	Each	22.0000	1.0000			
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
FP19	20	
53806 ✓	20	
Main Warehouse		
ST	2	
44659	1	
45825	1	

1 PR 16-01-14.

D3564-5 Manufactured No

200 Each 25.0000 1.0000



Wearshoe

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
34806	2	
Main Warehouse		
FP19	21	
51925	1	
53805 ✓	20	
Main Warehouse		
ST	2	
45824	1	
47433	1	

1 PR 10-01-14.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December 14, 2009 1:10:35 PM

Work Order ID: 54584



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 14/12/2009

Required Date: 21/12/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route # Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	* Status
D2594-3		Manufactured	No			200	Each	498.0000	16.0000			

O-Ring, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 27

51613 27

Main Warehouse

ST 471

52562 ✓ 471

D2594-1

Manufactured No

200 Each 281.0000 16.0000



Plug, 205 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP 54643 121

54008 121

Main Warehouse

ST 160

42221 16

42807 92

43884 3

46435 2

51527 9

51757 38

16. BR 10-01-14.

16. BR 10-01-14.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

RELEASED
07.06.28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

STANDARD
LTD
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 54584

BT 09-12-14

GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:
SEE NOTES ON
PAGE 2 FOR D2580-041 AND
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

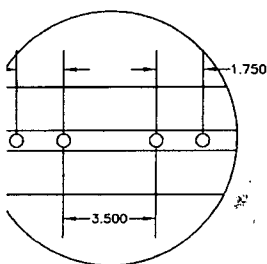
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

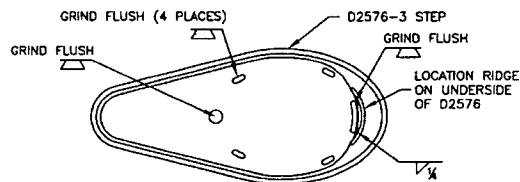
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A
SCALE 5:24

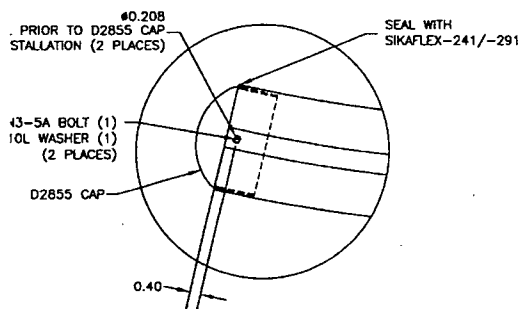


DETAIL B
SCALE 5:24

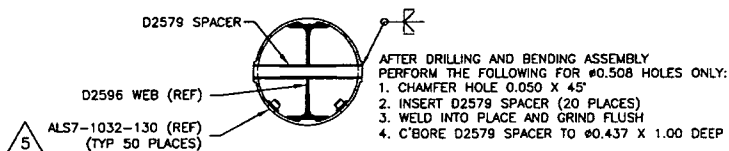


RELEASED
07-06-28-4

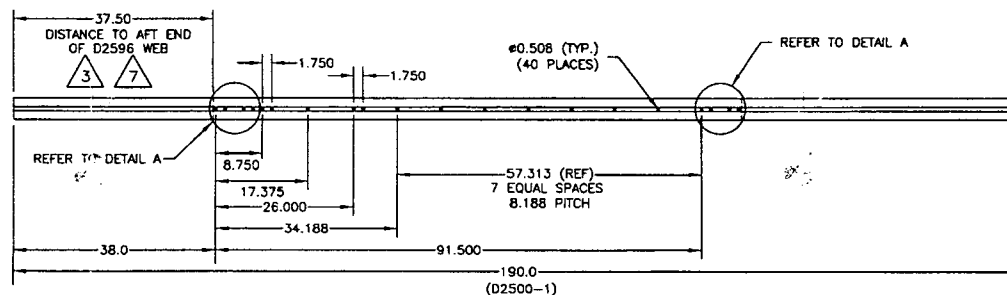
DETAIL C
SCALE 5:24



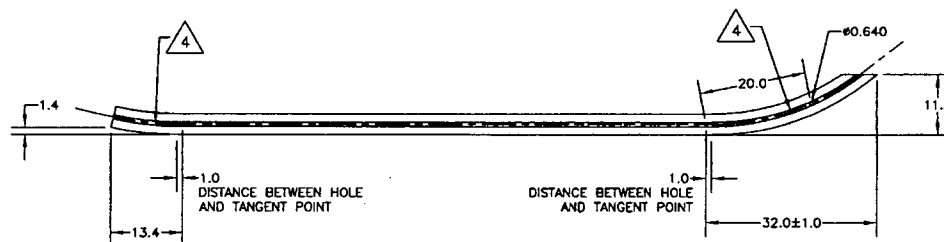
SECTION D-D
SCALE 5:24



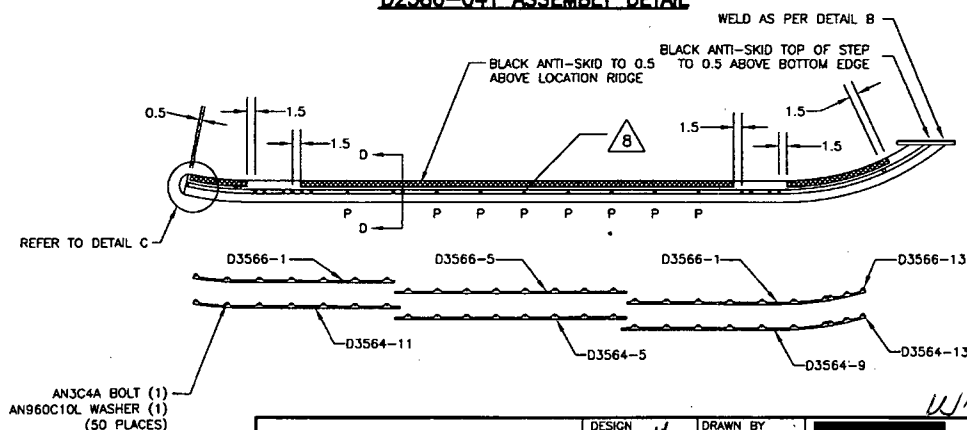
D2580-1 DRILLING DETAIL



D2580-1 BENDING AND CUTTING DETAIL



D2580-041 ASSEMBLY DETAIL



-041 NOTES

FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMMERSLEY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2580	REV. 0 SHEET 2 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

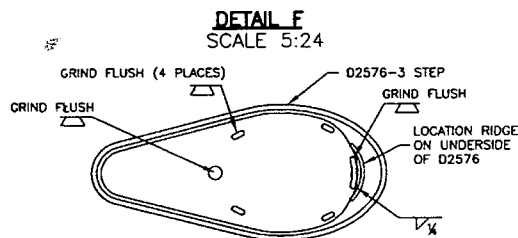
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SCALE 5:24

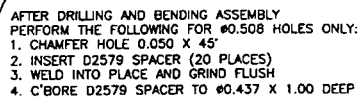


RELEASED
07 Dec 28

SCALE 5:24

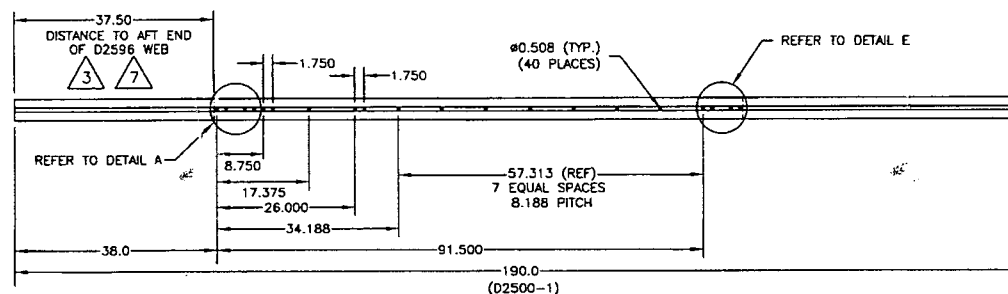


SECTION H-H
SCALE 5:24



INISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

D2580-1 DRILLING DETAIL



(MAKE FROM D2580-1 DRILLING DETAIL)



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DESIGN

DRAWN BY

DART

DART AEROSPACE LTD.
HAWKESBURY, ONTARIO, CANADA

CHECKED *ja*

APPROVED

DRAWING NO	D2580
------------	-------

REV. D
SHEET 3 OF 3

DATE _____

TITLE
205 SKIDTUBE ASSEMBLY

SCALE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 221

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berclay Elliott
Job number: 54202
Part number: D205 634 041
Description: 205 skid tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier P. D. J. Date of Test Coupon 09.12.17

Welder Berclay Elliott Date of Test Coupon 09.12.17

The above named individual is qualified in accordance with AWS D17.1.2001 to weld